

28

DART AEROSPACE LTD	Work Order:	21109
Description: Saddle Spacer	Part Number:	D2935
Drawing: D2935 Rev.A	Qty:	80
		Multiples of 40

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O	JA	04.06.14	80
2	METAL	1 blank makes 4 parts Blank: 7.90" x 3.70" (+0.030" - 0.000") M 15031 Material: 5052-H32/H34 (QQ-A-250/8) 0.080" Thick	RM	04/06/14	80
3	HAAS	Machine per folio FA073	SL	04/06/15	80
4	QC	Inspect Level 2	SL	04/06/15	80
5	QC	Inspect Level 8	DB	04-06-15	80
5	METAL	Tumble	RM	04/06/23	80
6	METAL	Deburr any rough edges after tumbling	SB	04/06/30	80
7	METAL	Acid etch and Alodine as per QSI 005 4.1	RM	04-06-05	80
8	QC3	Inspect Level 7 Alodine	IS	04-06-06	80
9	STORES	Identify and stock	CL	04/08/06	79
10	EXPEDITING	Close W/O Cost / part: 2.06 545 04/08/09 (79) Inspect level 21	JA	04.08.12	79

Rev	Date	Change	Revised By	Approved
A	00.06.06	New Issue	EC	

RELEASED

EC 00.06.06

RF

23.04.21

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR 21109		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B	Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector	
04/06/14	3	Jig moved due to 1/4-20 capscrew were tightened too deep (40 parts scrap) (1 stack)	Initial [Signature]	Scrap & replace 04/06/14	[Signature] 04/06/14	[Signature] 04-06-15	[Signature] 04-06-15	

PAR#: N/A. Fault Category: MANUS: CNC DQA: [Signature] Date: 04.08.12

NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncB.doc

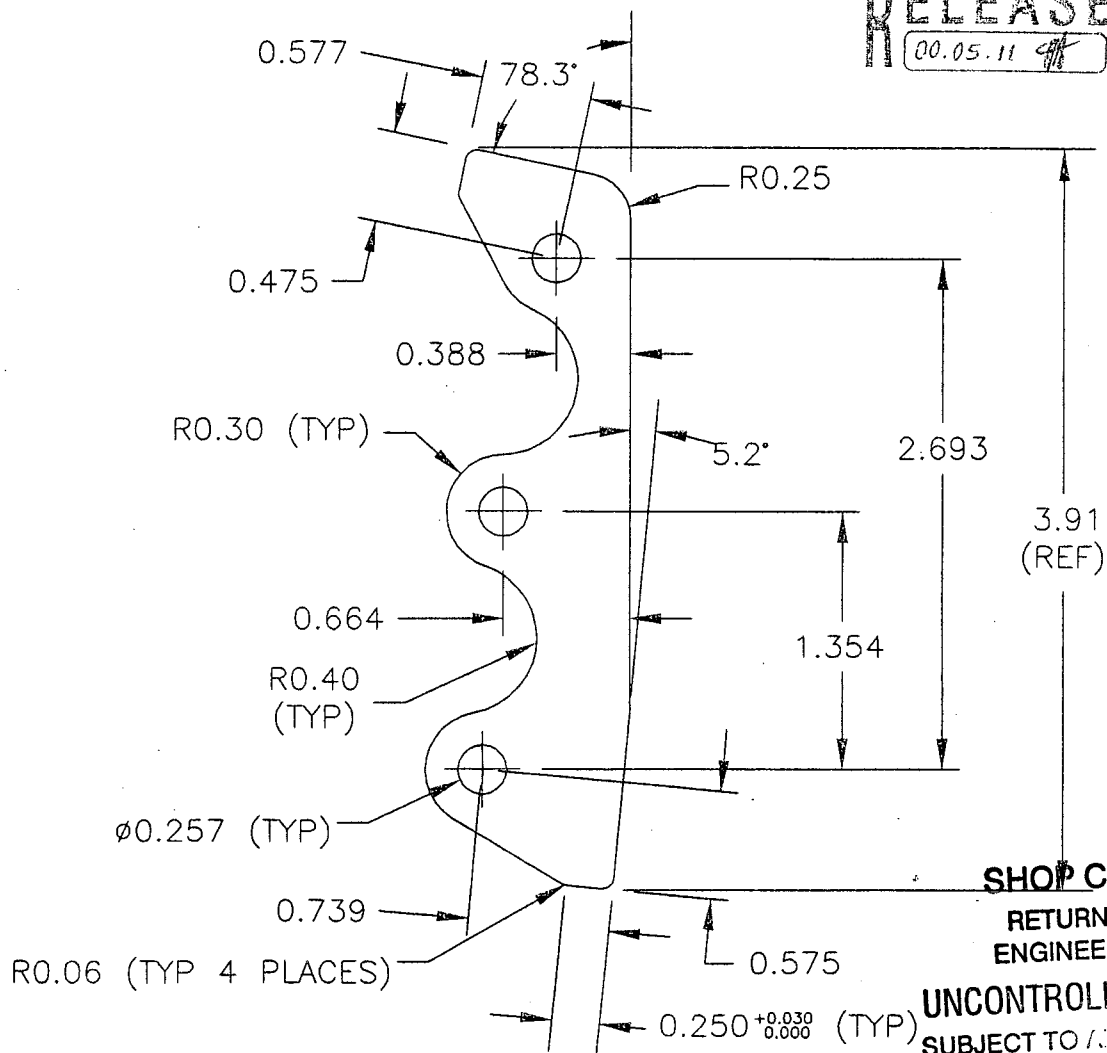
QA: N/C Closed: [Signature] Date: 04.08.12

Scrap
Scrap



DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2935	REV. A SHEET 1 OF 1
DATE 99.11.02		TITLE SADDLE SPACER	SCALE 1:1
A	99.11.02	NEW ISSUE	

RELEASED
00.05.11 *[Signature]*



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WORK ORDER

NO. 21109

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.080 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK ALL SHARP EDGES 0.010 TO 0.020

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jun 11, 2004
01:17 pm

Work Order No : 0021109
Project Name : D2935
Project For : WK428
Work Order Type : Main
Main WO Number :
House Part Number : D2935
Description : Saddle Spacer
Manufactured : Yes
Amount Req'd : 0
Amount Done : 0
Start Date : 06-11-04
Est Finish Date : 07-04-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Testing Hours :	0.00	0.00	0.00		
Testing Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
SubContract Hours :	0.00	0.00	0.00		
SubContract :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

